

20-8182



Dart Aerospace Ltd.
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D2586

Job Sheet R207049



Part No: D2586

Part Name: Door Latch



Part Weight: 0 lbs

Job Created: 2/18/20

Due Date: 2/21/20

Type: Rework

Job Qty: 77 pcs

Status: New

Priority: Medium

Job Tracking No: ECN2020-513

Created By: Linda Lacelle

Description:

Note: DWG D2586 REV F IPP E 02.01.31 Added inspect level 21 NG/IPP RevF: add not to keep key with latch DD 10.02.10 verified by:JLM//IPP Rev. G 2020.02.18 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
122	Rework - 1 - Startup	77 pcs	2/21/20	2/21/20	0.50	19.25	Conventional Lathe - 1 Conventional Lathe - 2		SL 20-2-19
123	QC 2	77 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1 QC 2 - 12 QC 2 - 14 QC 2 - 17 QC 2 - 19 QC 2 - 2 QC 2 - 20 QC 2 - 22 QC 2 - 23 QC 2 - 25 QC 2 - 32 QC 2 - 33 QC 2 - 35 QC 2 - 39 QC 2 - 4 QC 2 - 40 QC 2 - 44 QC 2 - 45 QC 2 - 48 QC 2 - 49 QC 2 - 50 QC 2 - 51 QC 2 - 52 QC 2 - 57 QC 2 - 62 QC 2 - 63 QC 2 - 8 QC 2 - 66		PTO

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Container No: S270341

Part: D2586

Job No: R207049

Serial No/Batch: S270341

Revision: Rev F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 04/14/20

				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
124 QC 8	77 pcs	2/21/20	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	mmu 20/04/14
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - 2 - B4B	77 pcs	2/21/20	0.00 4.95	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
140 QC 5	77 pcs	2/21/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	81
				QC 5 - 49	9-89
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Packaging 3-1 - Stock - B4B	77 62 pcs	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	DAS
					Packaging 3 - 3 - B4B ✓	80
					Packaging 3 - 4 - B4B	9-89
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	APR 28 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
160	QC 21 - SA	77 pcs	2/21/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
					Broussard	

Part Op 122 - 1-Remove latch lever. 2-Machine latch body as per drawing detail F-F. 3-Deburr 4-Keep latch lever and body
 Descriptions: together as a pair for reassembly at sequence 130.

123 - (QC2- Inspect parts off machine FAI/FAIB)

124 - (QC8- Inspect parts - second check)

130 - (Small Fab) 1-Touch up ALODINE and paint as per drawing note 2. 2-Reassemble latch arm to latch body. 3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg & Stock Location: _____) ***Ensure key is bag with latch***

160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2586	Door Latch	77 pcs (1 ea)	130-Small Fab - 2 - B4B	
D3015-7	Lock Nut	77 pcs (1 ea)	130-Small Fab - 2 - B4B	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
130-Small Fab - 2 - B4B	D2586	77	50	0
	D3015-7	77	121	0
Part Specifications				
Specifications could not be found.				

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Part Number	Operation Number	Operation	Container No	Job	Master Unit Number	Quantity	Weight	Serial No/Batch	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No	Expiration Date
Part Number: D2586 Revision: Door Latch																	
D2586	110	Packaging 2-1 - Receive - B4B	S254088	206135		50 pcs	0	S254088	Packaging 2 - 5 - B4B		WIP	2/7/2020					
Operation Totals:			1			50	0										
D2586	160	QC 21 - SA										10/10/2017	Will need to be re-worked/ returned as part does not function with current dimensions. VM				
			F152211			2 pcs	0	152211	Broussard		Quarantine						
			S223350	201623		23 pcs	0	S223350	Quarantine Bin		Quarantine	10/17/2019	Will need to be re-worked/ returned as part does not function with current dimensions				
			S233490	203068		4 pcs	0	S233490	Quarantine Bin		Quarantine	11/20/2019	Will need to be re-worked/ returned as part does not function with current dimensions. VM				
			S245345	204564		50 pcs	0	S245345	Quarantine Bin		Quarantine	1/7/2020	Will need to be re-worked/ returned as part does not function with current dimensions. VM				
Operation Totals:			4			79	0										
Part Totals:			5			129	0										
Totals:			5			129	0										

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Handwritten notes:

- A circled "FE" with a checkmark.
- A box containing the number "73".

Entered: JKDate: June 23/2000

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8182Route update only ☐

Job: <u>R207049</u> Part No. <u>D2586</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>20-4-14</u>		Sequence #: <u>122</u>		QTY Affected: <u>72</u>			MRB (QSI042) DAS 9 20-4-14 Completed By <u>JK</u> 20-4-14 Lead hand / Supervisor <u>JK</u> 20-04-14 QC / QA Coordinator DAS 9 20-4-14		
Description Work Order Deviation				Disposition					
- 1 part is scrap - roll pin was crushed during disassembly - unable to use				- SCRAP					
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☒ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							